Work Order ID 73975

Tuesday, September 20, 2011 10:22:04 AM

Item ID: D3777-041 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Clamp

Start Date: 9/20/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 10/4/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-09-20 **Tooling:** **Date:** **Run** **Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3777	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Waterjet FLOW CNC Waterjet 304.032	FLOW WATER JET **Memo** 1-Cut as per Dwg D3777-1 Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00 0.00				FB 11-9-20 (24)			
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				FB 11-9-20			
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	S 11/09/21			(x24)			

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73975

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Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab **Memo** 1- Deburr any rough edges.:2- Form as per Dwg D3777	0.00 0.00	SD 11/12/23						
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	S 11/12/23			counted x24			
150 Small Fab Small Fab	Small Fab **Memo** Assemble rubber cushion as per dwg D3777	0.00 0.00	SD 12/01/04			24			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73975

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Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 12/01/04				counts (24)			
170 Packaging Packaging	Identify as per dwg & Stock Location: ST 81 **Memo**	0.00 0.00				(24x) SP 12-01-05			
180 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00				GK 12/01/06			

M.L-J 12/01/05

(24)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:22:02 AM

Work Order ID: 73975

Parent Item: D3777-041

Parent Item Name: Clamp

Start Date: 9/20/2011 **Required Date:** 10/4/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B013 Rubber cushion		Manufactured	No			100	Each	0.0000	1	6	SD	12/01/04	
M304S22GA 304/316 .032 Sheet		Purchased	No			150	sf	138.3600	0.02	0.126316	.5	EB 11-9-20	

D-66063 B73632

Location		Loc Qty	Loc Code
020		3.3	
	109057	3.3	
MAT020		135.06	
	117379	31.56	
	118271	96	
	118400	7.5	118400

(24)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

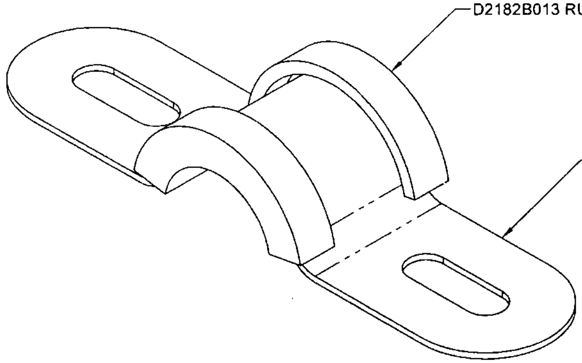
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

QTY -041	P/N	DESCRIPTION
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



D3777-041 CLAMP

#73975

RELEASED 08.10.15

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	08.04.25

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	PH	DRAWING NO. D3777	REV. A SHEET 1 OF 3
MFG. APPR.	[illegible]		
APPROVED	[illegible]	TITLE CLAMP	SCALE NTS
DE APPR.	[illegible]		
DATE	08.04.25		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

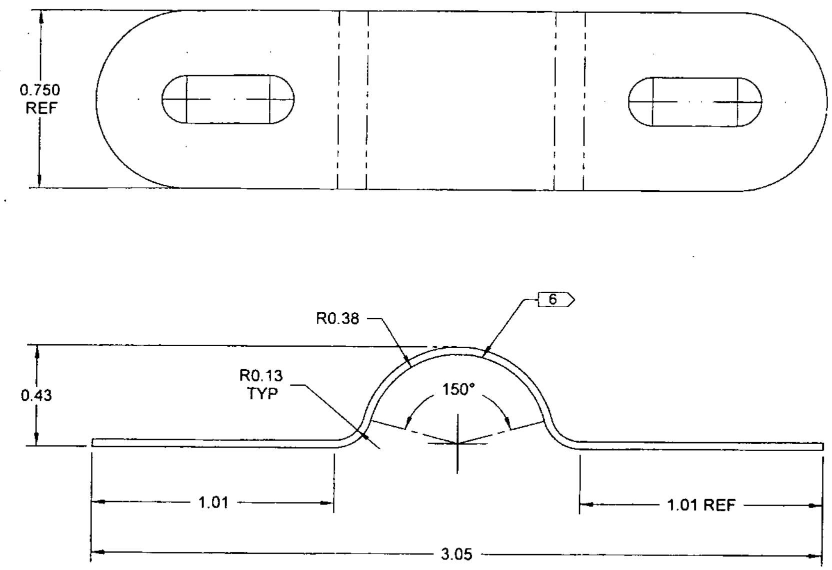
Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

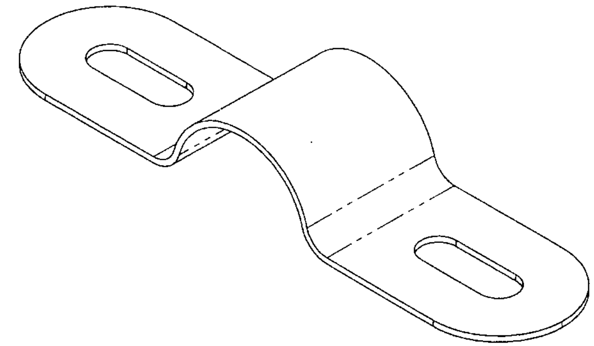
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D3777-1 CLAMP



#73975

RELEASED

NOTES:
1) MATERIAL: MAKE FROM D3777-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1"USING FINE POINT PERMANENT MARKER
7) WEIGHT: 0.02 lbs

DESIGN	GP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	GP	DRAWING NO. D3777 — REV. A — SHEET 2 OF 3
CHECKED	PH	
MFG. APPR.	MP	
APPROVED	MP	TITLE CLAMP — SCALE NTS
DE APPR.	[illegible]	
DATE	08.04.25	

Dart Aerospace Ltd

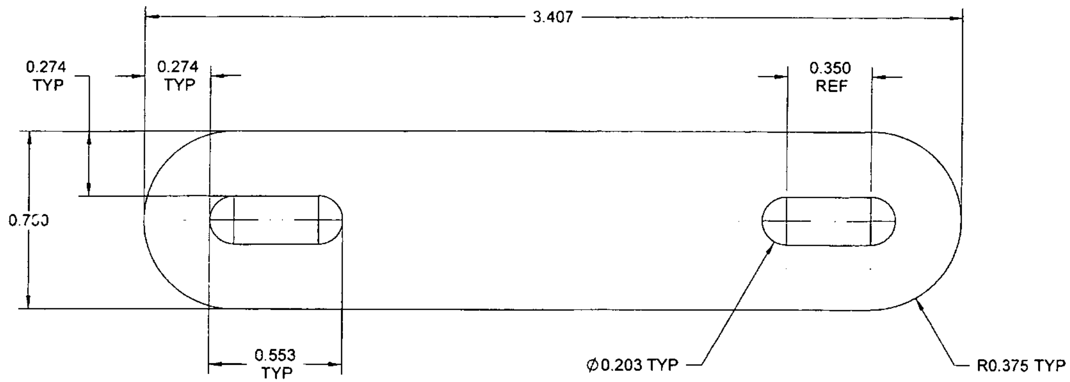
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3777-1F CLAMP

#73975

RELEASED 08.10.15

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.02 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3777 — REV. A — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE CLAMP — SCALE NTS
DE APPR.		
DATE	08.04.25	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73975
Description: Clamp	**Part Number:**	**D3777-1**
Inspection Dwg: D3777 **Rev:** A		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	.204	✓		V HBG	
0.350	+/-0.010	.352	✓		V	
0.553	+/-0.010	.556	✓		V	
0.750	+/-0.010	.754	✓		V	
0.274	+/-0.010	.275	✓		V	
0.274	+/-0.010	.276	✓		V	
3.407	+/-0.010	3.411	✓		V	

Measured by:	HB
Date:	11-9-20

Audited by:	[signature]
Date:	11/09/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue P/O D3777-041	KJ [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries